

Date: Thursday, 02/04/2009 2:29:04 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 46893	
Estimate Number : 13169	
P.O. Number :	Part Number : D37301
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3730 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 39053	Material :
Written By :	Due Date : 14/04/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 09.04.03</u>	
Comment : Est Rev:A 08-01-30 new issue DD verified by:	
Est Rev:B 08-03-19 chg to revB ecn 1158 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6A750W125	angle .750 x .750 x .125w
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Comment: Qty.: 0.1749 f(s)/Unit Total: 2.0992 f(s) $(2.125 \times 14) \div 12 = 2.479'$
 D6207 angle extrusion
 Batch: M18147

AP 09/04/05 04

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut to Length as per Dwg D3730

AP 09/04/05 04

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: 1- drill holes as per dwg D3730

2-Deburr

AP 09/04/05 04

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

AP 09/04/04 (14)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

AP 09/04/04 (14)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ANGLE

Job Number: 46893

Part Number: D37301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



14X

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3730

2- Deburr if necessary

M-L 09/04/06

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/07 (14)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(14)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMDI FL

09/04/07

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(14)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-8

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SDENVW

09/04/8 (14)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09-04-08

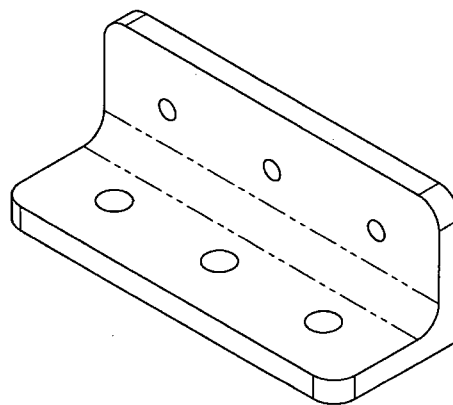
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries







D3730-1 ANGLE 

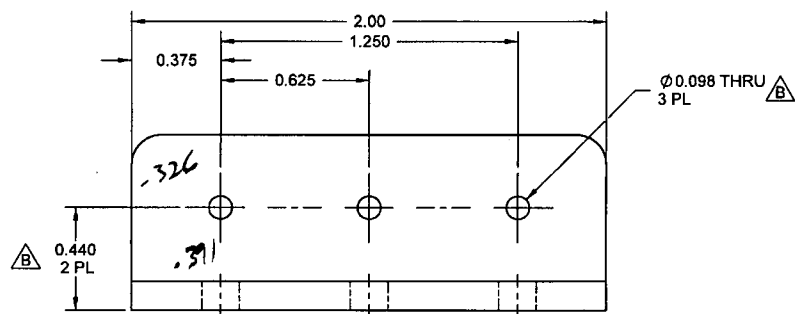
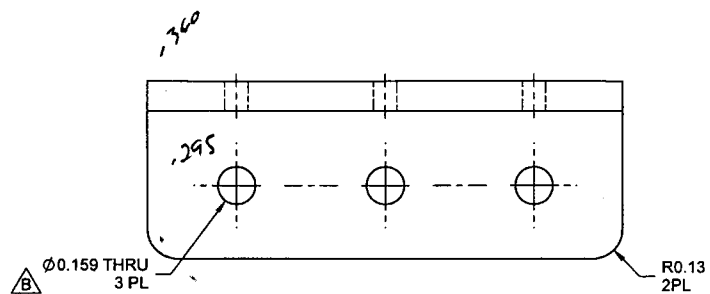
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NOTES:

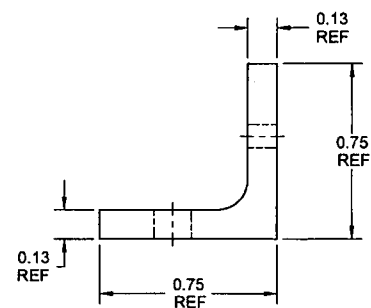
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
 PER AMS-QQ-A-200/8
 (REF. DART SPEC. M6061T6A750XW125) 
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

08.03.06

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED. ISO VIEW UPDATED. SHEET 2 ZONE C4, Ø0.098 HOLES WERE Ø0.159, ZONE 7B 0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.01.31
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3730	SHEET 1 OF 2	
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DE APPR.		ANGLE	NTS	
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D3730-1 ANGLE



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08-03-17-1P

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MFG. APPR.	DS	D3730	SHEET 2 OF 2
APPROVED	740	TITLE	SCALE
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